

Work Order ID 86077

June-20-12 12:55:20 PM

86077

Page 1

Item ID: 41232-200-004-001

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Reducer Tee Assembly

Stop ***NS2***

Start Date: 20/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/06/20

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

41232-200-004

Rev IR

100

0.00

100

CONVENTIONAL LATHE

Lathe Conv

Memo

0.00

12-07-03

2

PTO

Conventional Lathe

1-Turn AN815-4J as per Dwg 41232-200-0042-Deburr as Required.

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

12-07-03

2

Conventional Milling Machine

1-Drill as per Dwg 41232-200-00
2-SPOT FACE 5/8" TO LOCATE FITTING FOR WELDING
3-Deburr

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

12-07-03

2

Quality Control

W/O: 86077

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ~~4~~ 41232-200-004-001 PAR #: _____ Fault Category: Machin NCR: Yes No DQA: hjh Date: 12/09/18
 Resolution: SCNAD Disposition: Scrap QA: N/C Closed ck Date: 12/9/20

NCR: 12-1811		WORK ORDER NON-CONFORMANCE (NCR) 391.45						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-07-03	100	AN 815-45 Fitting SLIPPED, while Machining in lathe Batch M 104253	<u>S</u> Q57042 12/07/03	Scrub + Destroy. Qty 1	<u>AD</u> 12-07-3	<u>S</u> 12/07/03	<u>S</u> 12/07/03 Q57042	<u>S</u> 12/07/03
		R.C operator error improper holdig of part						

NOTE: Date & initial all entries

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Page 2

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Start Date: 20/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Large Fab

0.00

140

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg 41232-200-004 A/R
Batch: M114509

SS Rod

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

1-WELD INSPECTION 2-Pressure test as per Dwg 41232-200-0043-
Passivate Finish.

tested to 3000 psi
pickling solution
passivating solution
M115 318
12-08-23
12-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 86077

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Page 3

Item ID: 41232-200-004-001

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Reducer Tee Assembly

Stop ***NS2***

Start Date: 20/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: **377**

0.00

160

Packaging

Memo

0.00

Packaging

22 / 8 12/9/17

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/9/18

12-09-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-20-12 12:55:24 PM

Page 1

Work Order ID: 86077

Parent Item: 41232-200-004-001

Parent Item Name: Reducer Tee Assembly

86077

41232-200-004-001

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-03-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN815-4J		Purchased	No			100	Each	8.0000	1	2			
----------	--	-----------	----	--	--	-----	------	--------	---	---	--	--	--

AN815-4.1

union

**

Location

Loc Qty

Loc Code

ST324

8

104253

4

115101

4

AS1035J080812

Purchased

No

100

Each

6.0000

1

2

AS1035.1080812

TEE

**

Location

Loc Qty

Loc Code

ST283

6

115055

6

2 ~~12~~ 12-07-03

2 ~~12~~ 12-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

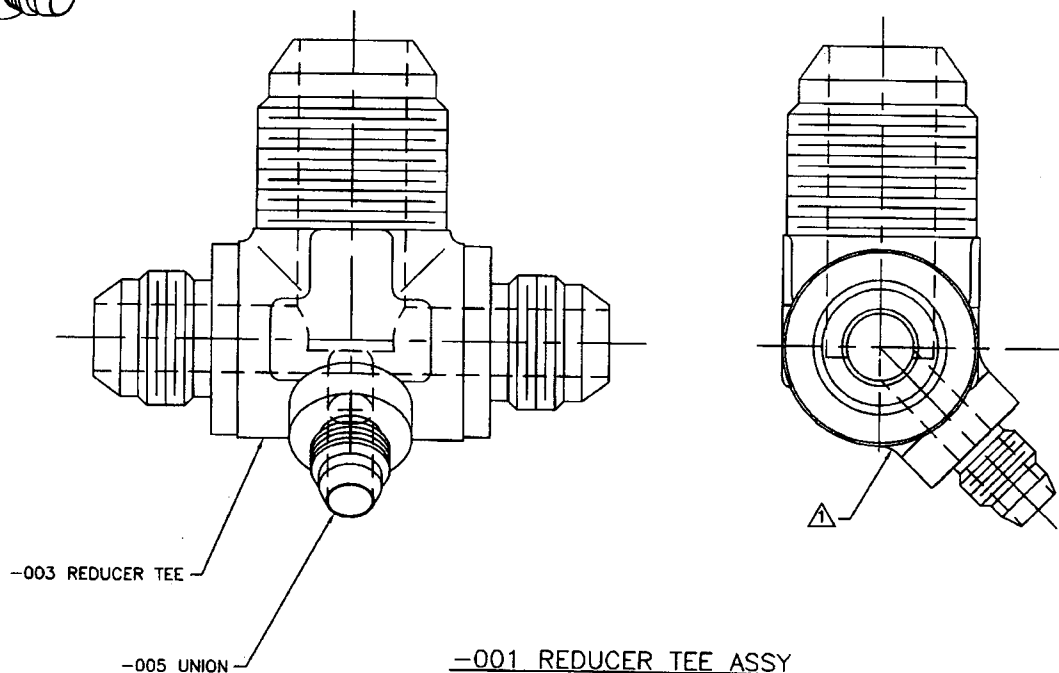
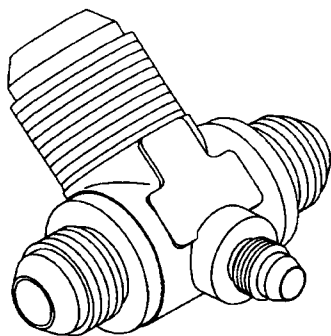
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86077 MCT
12/06/20

- △ PRESSURE TEST TO 3,000 PSI.
- △ QQ-P-35 PASSIVATE FINISH AFTER WELD.
- △ WELD IN ACCORDANCE WITH MIL-STD-2219 CLASS C.

NOTES:

NO. REQ'D PER ASSY		PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
1		-005	UNION		MAKE FROM AN815-4J UNION		
1		-003	REDUCER TEE		MAKE FROM BELL P/N AS1035J080812 or 110-080-12C		
1		-001	REDUCER TEE ASSY				
NO. REQ'D PER ASSY		PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
2		41232-000-001	REDUCER TEE ASSY				
UNLESS OTHERWISE SPECIFIED				LIST OF MATERIAL			
X ± .1				DRAFTSMAN D. NELSON 5/24/02			
XX ± .03				CHECK D. MURPHY 5/24/02			
XXX ± .010				STRESS			
ANGLES ± 1/2°				PROJ. ENGR.			
HEAT TREAT				DWG. SIZE C SCALE 2:1			
FINISH				Eva Aviation, Inc.			
DWG. NO. 41232-200-004				SHT 1 OF 2			
REV. IR							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

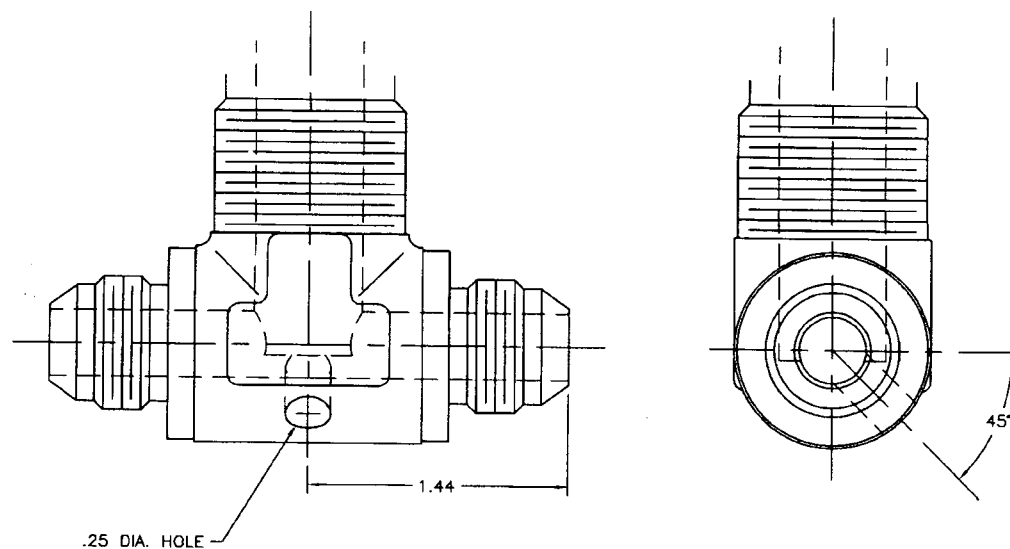
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

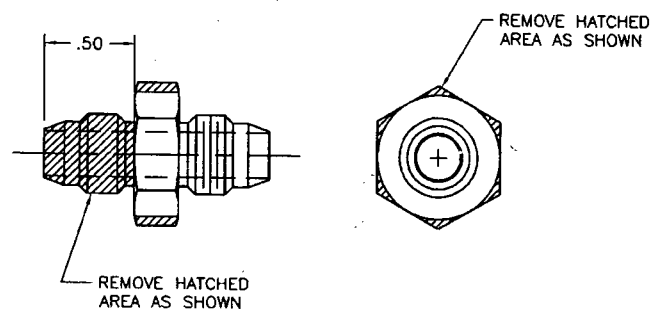
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86077



-003 REDUCER TEE



-005 FITTING

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Era Aviation, Inc.

TITLE

REDUCER TEE ASSY

SIZE

C

ORD. NO.

41232-200-004
 SHT 2 OF 2

REV.

IR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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